

Date: Thursday, 6/15/2006 1:46:51 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)	
Job Number	: 27576A		Part Number	: D2221	
Estimate Number	: 10189		Drawing Number	: D2221/D2235	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/15/2006 S.O. No. : N/A		Drawing Revision	: F/B1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 7/5/2006	
Previous Run	: 27575A		Qty:	1 Um: Each	
Written By	: <i>Sig A</i> COMMENT Below				
Checked & Approved By	: <i>7/15/06 - 06.15</i>				
Comment	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D31661	Basket Hoop			
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)			
		Pick:			
		Qty Part Number Description Batch			
		4 D3166-1 RIB <i>B27526</i>		<i>PD</i>	<i>06-06-22</i> <i>(1)</i>
2.0	D22323	Basket Hinge			
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
		Pick:			
		Qty Part Number Description Batch			
		2 D2232-3 Hinge bracket <i>B24527</i>		<i>PD</i>	<i>06-06-23</i> <i>(1)</i>
3.0	D2325	Support Gusset (350 Bask)			
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)			
		Pick:			
		Qty Part Number Description Batch			
		4 D2325 Support Gusset <i>B26741</i>		<i>PD</i>	<i>06-06-23</i> <i>(1)</i>
4.0	D23273	Spacer Bushing			
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
		Pick:			
		Qty Part Number Description Batch			
		2 D2327-3 Bushing <i>B27051</i>		<i>PD</i>	<i>06-06-23</i> <i>(1)</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:46:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27576A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B27524

PD

06-06-23 (1)

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B26739

PD

06-06-23 (1)

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal M101553

PD

06-06-23 (1)

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M101309

PD

06-06-21

(1)

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD 06-06-23 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/15/2006 1:46:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27576A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

Neq/06/28 ①

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/07 ①

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-07-12 ①

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M101193

Expiry date: 01/2006

MF . 06.07.10

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

A 06.07.14

Job Completion



U 26.07.14

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS

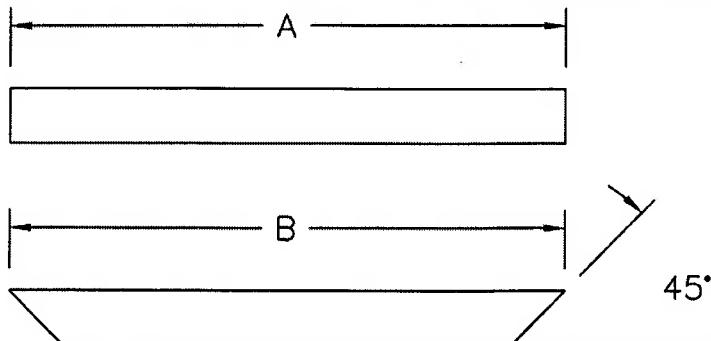
RELEASED

05.08.19 *[initials]*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

A
45°

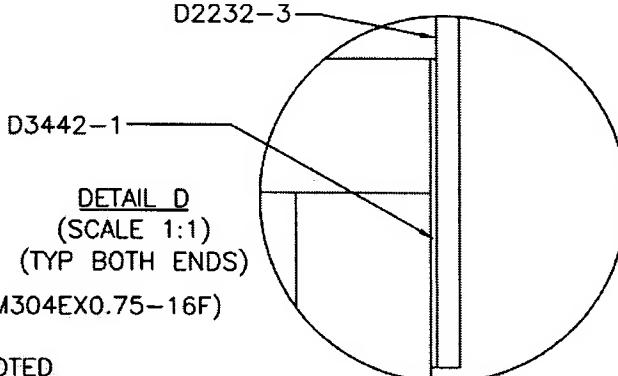
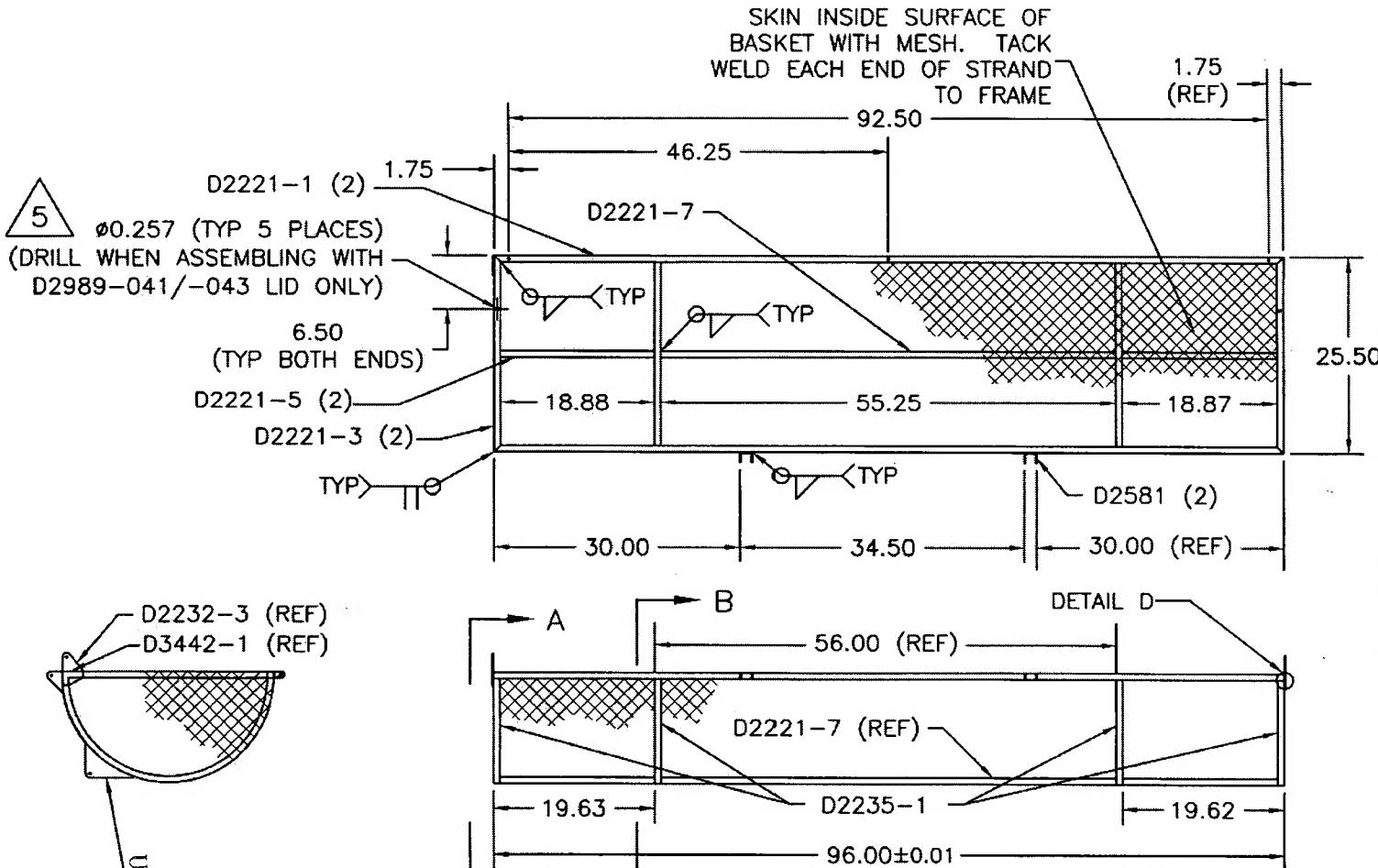
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WORK ORDER
A

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)	SHEET 2 OF 3	REV. F



NO. 275 Rev A

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05.08.19 *[Signature]*

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D2325 (REF)

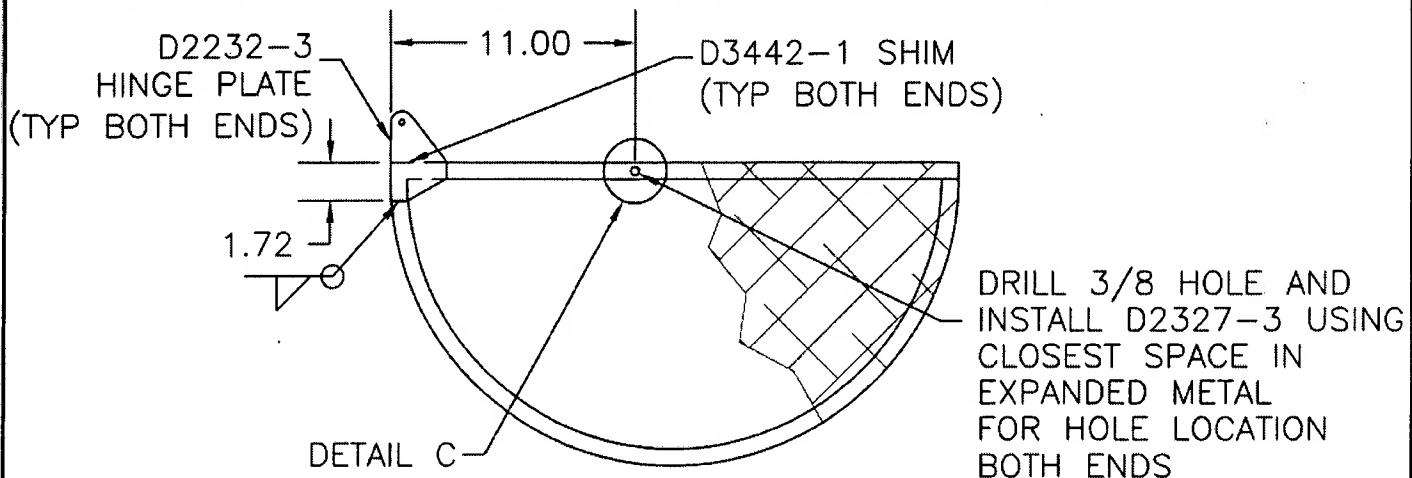
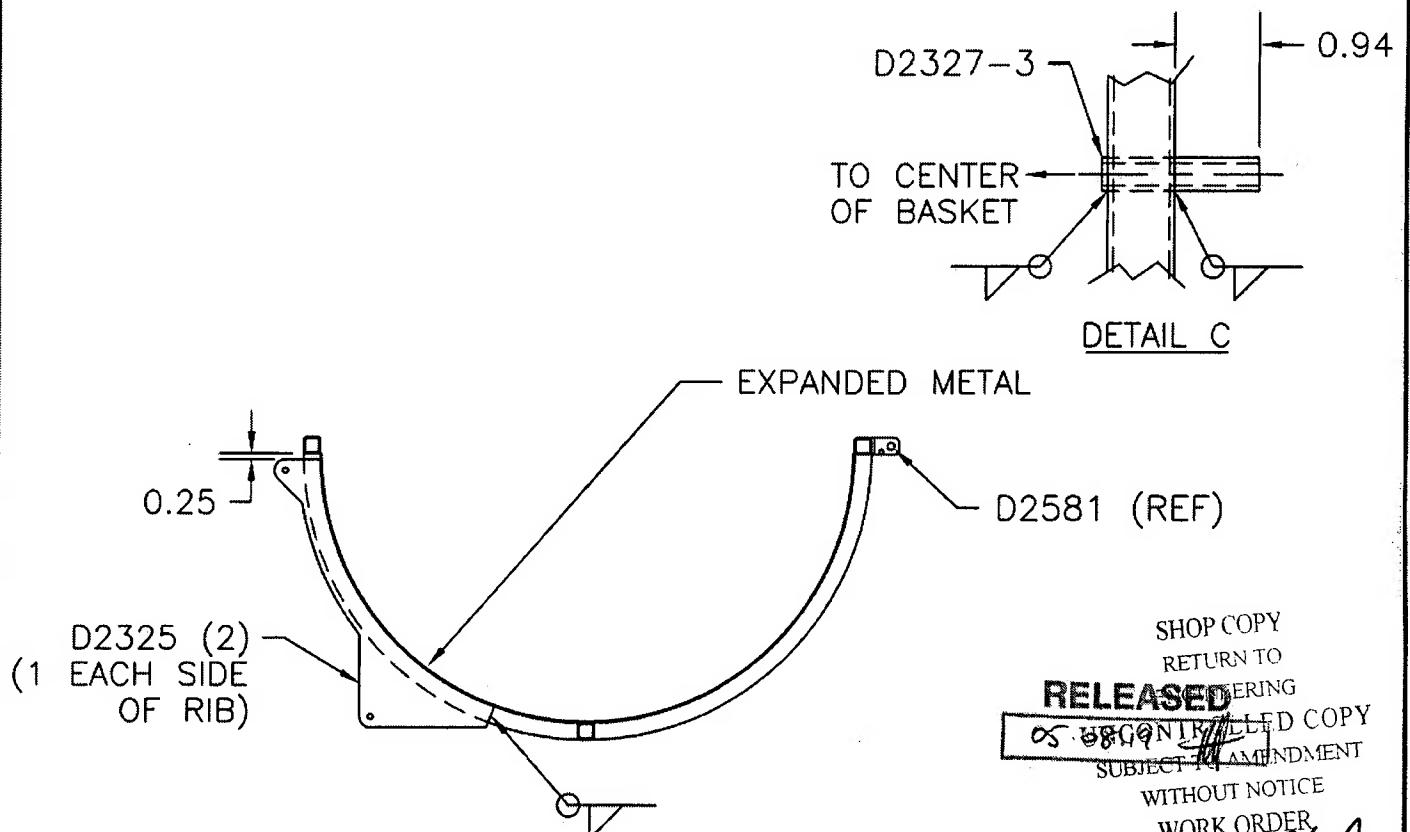
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D2221 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8

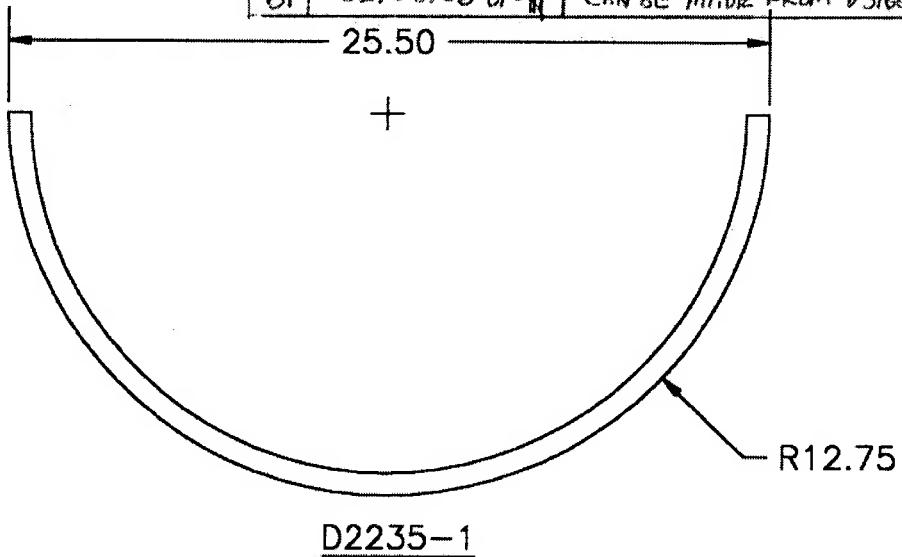
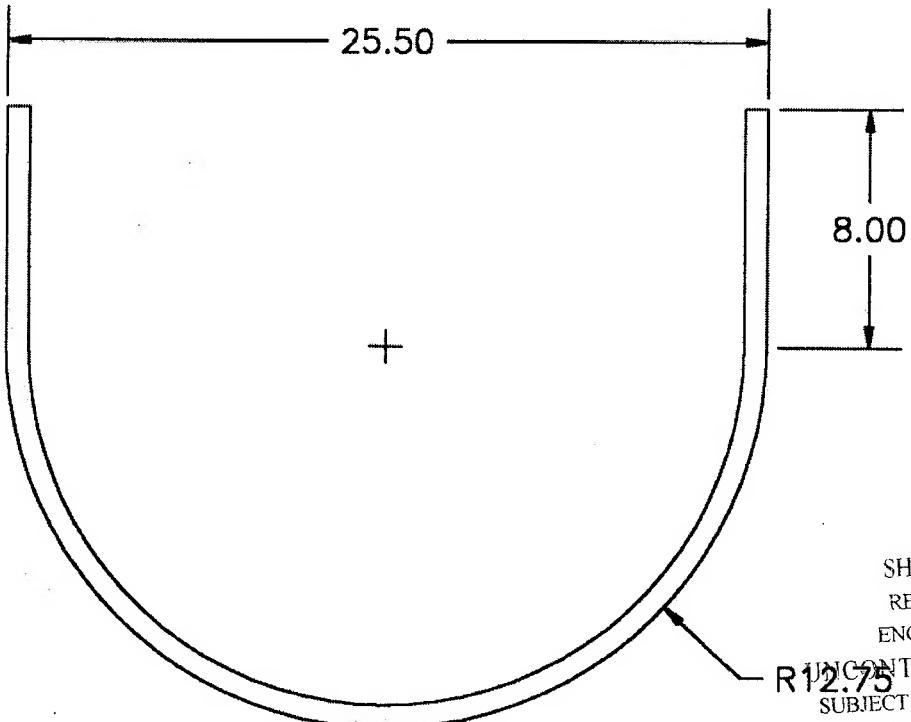
SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

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DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		REV. B SHEET 1 OF 1
		TITLE SCALE BASKET RIBS

B1 02.08.06 *BP* CAN BE MADE FROM D3166-1**RELEASED**
R 960507D2235-1D2235-3

CAN BE MADE FROM D3166-1 *Bi*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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